


Date: Thursday, 4/19/2007 10:06:22 AM  
 User: Eric Charbonneau

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	ARM
<b>Job Number</b> :	31954		
<b>Estimate Number</b> :	12590		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D35604
<b>This Issue</b> :	4/19/2007	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3560 UNDER REVIEW
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	31447	<b>Drawing Revision</b> :	A
		<b>Material</b> :	N/A
<b>Written By</b> :		<b>Due Date</b> :	4/23/2007
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	1
<b>Comment</b> :	Est Rev:A New Issue 06-11-10 JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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**Comment:** Qty.: 0.7350 f(s)/Unit Total: 0.7350 f(s)

6061-T6 Bar .50" x 6.0"

Batch: M101919 X ml 070419 (1)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: U/R

Prog Rev: U/R

ml 070419 (1)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** Machine as per Dwg D3560

ml 07100420 (1)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 070420 (1)

6.0	QC8	SECOND CHECK ENGINEERING APPROVAL
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**Comment:** SECOND CHECK

ml 070420

ml 070420 (1)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 31954

Part Number: D35604

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *11A-25*

FOR ENGINEERING USE ONLY

*11E-02-04-24*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*11A-04-25*

Job Completion



*change*

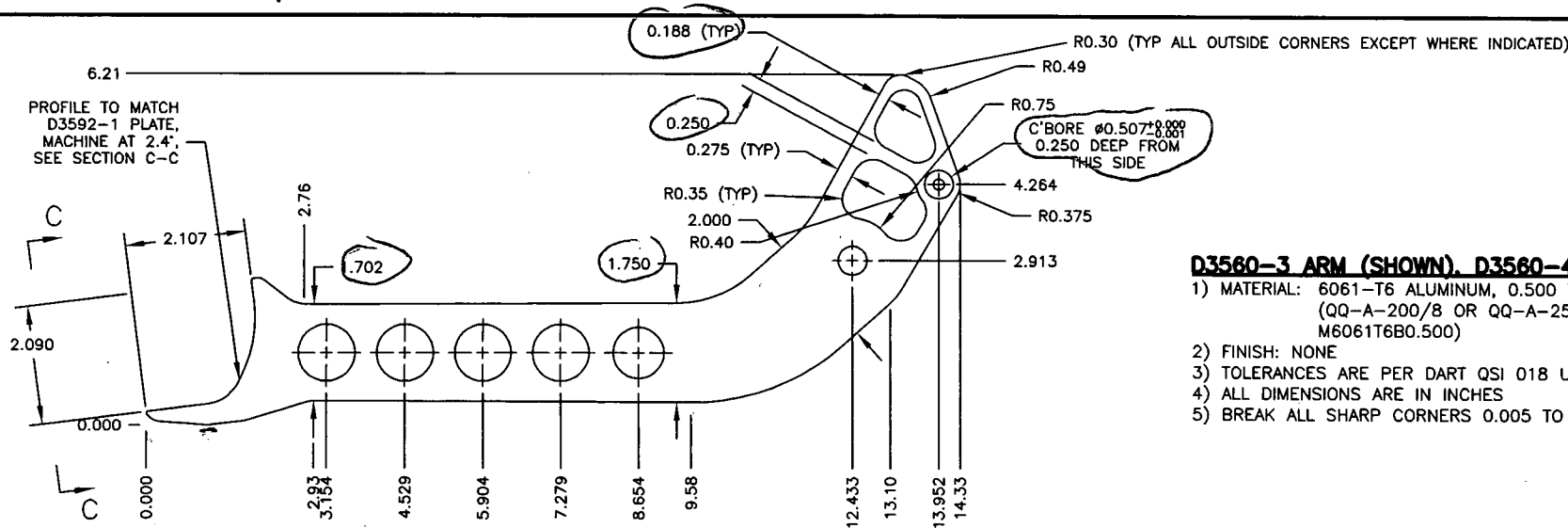
*00075*

*11A-04-25*

2020, 2021, 2022

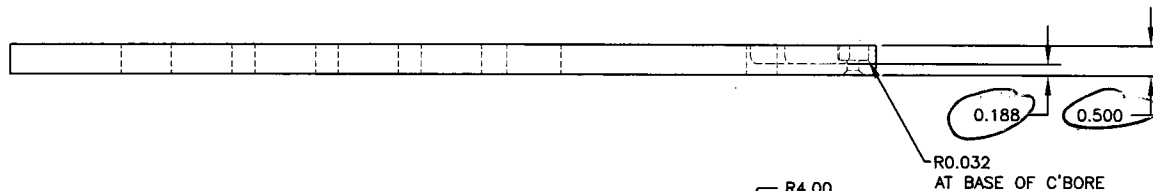
PRELIMINARY ISSUE

PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4",  
SEE SECTION C-C

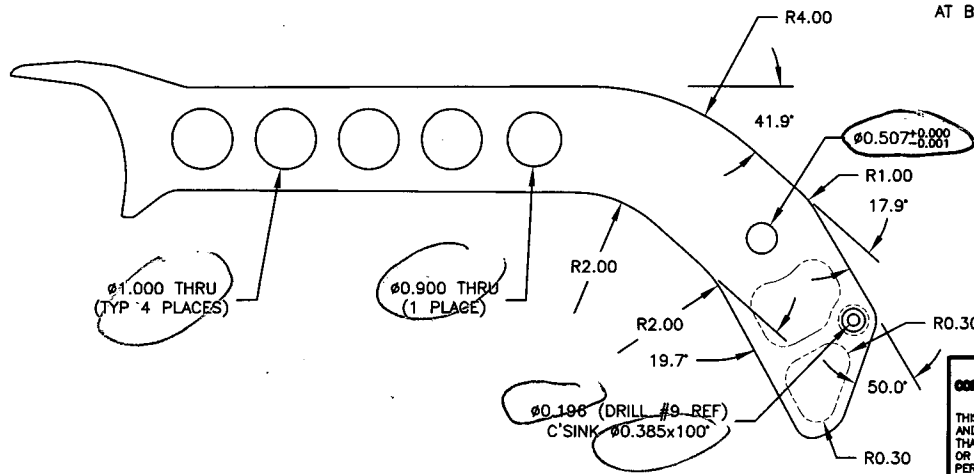
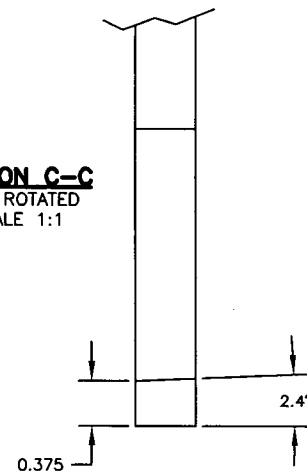


**D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.  
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



**SECTION C-C**  
VIEW ROTATED  
SCALE 1:1



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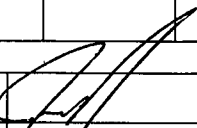
DESIGN	47	DRAWN BY	47	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3560	REV. C SHEET 3 OF 3
DATE	07.04.10	TITLE	ARM WELDMENT	SCALE	1:2

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b>		<b>Part Number:</b>	D3560-4
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	$\pm 0.01$	0.188	✓			
Ø.507	$\begin{matrix} +0.000 \\ -0.001 \end{matrix}$	Ø.506	✓			
0.250	$\pm 0.01$	0.249	✓			
1.702	"	1.701	✓			
1.750	"	1.748	✓			
0.250	"	0.251	✓			
<hr/>						
0.188	$\pm 0.01$	0.187	✓			
0.500	"	0.501	✓			
<hr/>						
Ø.507	$\begin{matrix} +0.000 \\ -0.001 \end{matrix}$	Ø.507	✓			
Ø.385x100°	$\pm 0.01$	Ø.390x100°	✓			
Ø.196	$\begin{matrix} +0.005 \\ -0.001 \end{matrix}$	Ø.197	✓			
Ø.900	$\begin{matrix} +0.007 \\ -0.001 \end{matrix}$	Ø.901	✓			
Ø 1.000	"	Ø 1.000	✓			

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	
<b>Date:</b>	07.04.20	<b>Date:</b>	07.04.20	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	